

Split

Sub Nov 29

Work Order ID 153242 *2*

153242

Monday, November 14, 2016 8:44:16 AM

Item ID: 646.9703 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Cutter Sub Assembly
Start Date: 11/15/2016 Start Qty: 4.00 *4* Cust Item ID:
Required Date: 11/17/2016 Req'd Qty: 4.00 *4* Customer:
Reference:

Approvals: Process Plan: *VS* DAS 21 Date: 16/11/14 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
646.9700	REV D2								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120		0.00							
120									
Small Fab	Memo	0.21							
Small Fab	Assemble as per dwg and apply loctite 598 on all faying surfaces per note.								
	A/R RTV LOCTITE 598: 135479								
	exp. date: 04/18								
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.01							
Quality Control									

NOV 14 2016
DAS 6
9-89

3X *16/12/12*
DAS 36
9-89

16.12.19
DAS 9
9-89

Work Order ID 153242

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Item ID: 646.9703**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Cutter Sub Assembly**Start Date:** 11/15/2016 **Start Qty:** 4.00***4*****Cust Item ID:****Required Date:** 11/17/2016 **Req'd Qty:** 4.00***4*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <i>22/0</i>	0.00				<i>1X</i>			<i>16/12/19</i>
140									
Packaging	Memo	0.01							
Packaging	***IDENTIFY AS PER IAW MPP-120***								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.07							
Quality Control									

DAS
21
9-89

DEC 19 2016

DEC 19 2016

DA
36
9-8

Picklist Print

Monday, November 14, 2016 8:44:27 AM

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Work Order ID: 153242

153242

Parent Item: 646.9703

646 9703

Parent Item Name: Cutter Sub Assembly

Start Date: 11/15/2016

Required Date: 11/17/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 16-03-07 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

646.9713		Manufactured	No				Each	3.0000		4		NOV 14 2016	DAS 6 9-89
646 9713									**				
Body													

Location	Loc Qty	Loc Code
CCK013	3	
146990	3	

646.9711		Manufactured	No				Each	52.0000		8		NOV 14 2016	DAS 6 9-89
646 9711									**				
Blade													

Location	Loc Qty	Loc Code
CCK106	12	
147263	12	
CCK108A	40	
148546	10	
150119	30	

MS27039-08-19		Purchased	No				Each	315.0000		24		NOV 14 2016	DAS 6 9-89
MS27039-08-19									**				
Screw													

Location	Loc Qty	Loc Code
GA	182	
m135948	182	
ST277	133	
m135865	33	
m136042	100	

601.2764	NAS1149FN832 P	Purchased	No				Each	0.0000		48		NOV 14 2016	DAS 6 9-89
601 2764									**				
Washer (NAS1149FN832P)													

DAS 6 9-89

Picklist Print

Page 2

Monday, November 14, 2016 8:44:27 AM

Work Order ID: 153242

153242

Parent Item: 646.9703

646.9703

Parent Item Name: Cutter Sub Assembly

Start Date: 11/15/2016

Required Date: 11/17/2016

Start Qty: 4.00

Required Qty: 4.00

601.1541 MS21042L08 Purchased No

Each 0.0000

24

601 1541

**

135672x10

DAS

6

NOV 14 2016

Locknut (MS21042L08) (8-32 Thd) (Cad Plated) (100 Q)

(35Kd x 14

9-89



TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

EFFECT ON DWG
☐ INC. ☒ UNINC.

EFF.	CURRENT ORDER
------	---------------

ECR: N/A

NOTES:

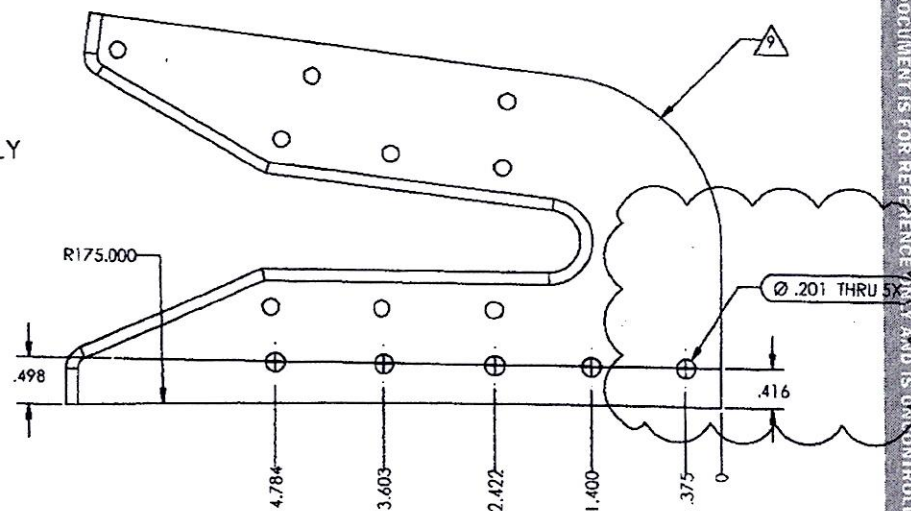
- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH IAW MPP-172 SECTION 2.1, 3.3 & 4.3.
- 3 MATERIAL: AISI A2 TOOL STEEL
CONDITION: ANNEALED
POST PROCESS: HEAT TREAT TO 58-62 Rc ROCKWELL HARDNESS
- 4 FINISH: PRIME IAW MPP-172 SECTION 3.3; 1-2 MIL MAX
5. DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED
6. IDENTIFY IAW MPP-120
- 7 APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 2 UPON ASSEMBLY
- 8 CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE
- 9 ALL DIMENSIONS NOT SPECIFIED ARE CONTROLLED BY 646.9710.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 153242

$$\frac{V_L}{L}$$

16/11/14

SHEET 7, ZONE C5 IS:



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DOCUMENTS EFFECTED:

☐ PATTERN ☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY
☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED
☐ YES ☒ NO



APICAL INDUSTRIES, INC.
dba DART AEROSPACE

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

ENGINEERING CHANGE NOTICE NO.

05360

SHEET 1 OF 1

DWG NO. 646.9700

REV: D

PREPARED BY J. BECKER

DATE: 03/24/16

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: CUTTER SUB ASSY

APPROVED BY: ENGR. [Signature]

MFG [Signature]

QC [Signature]

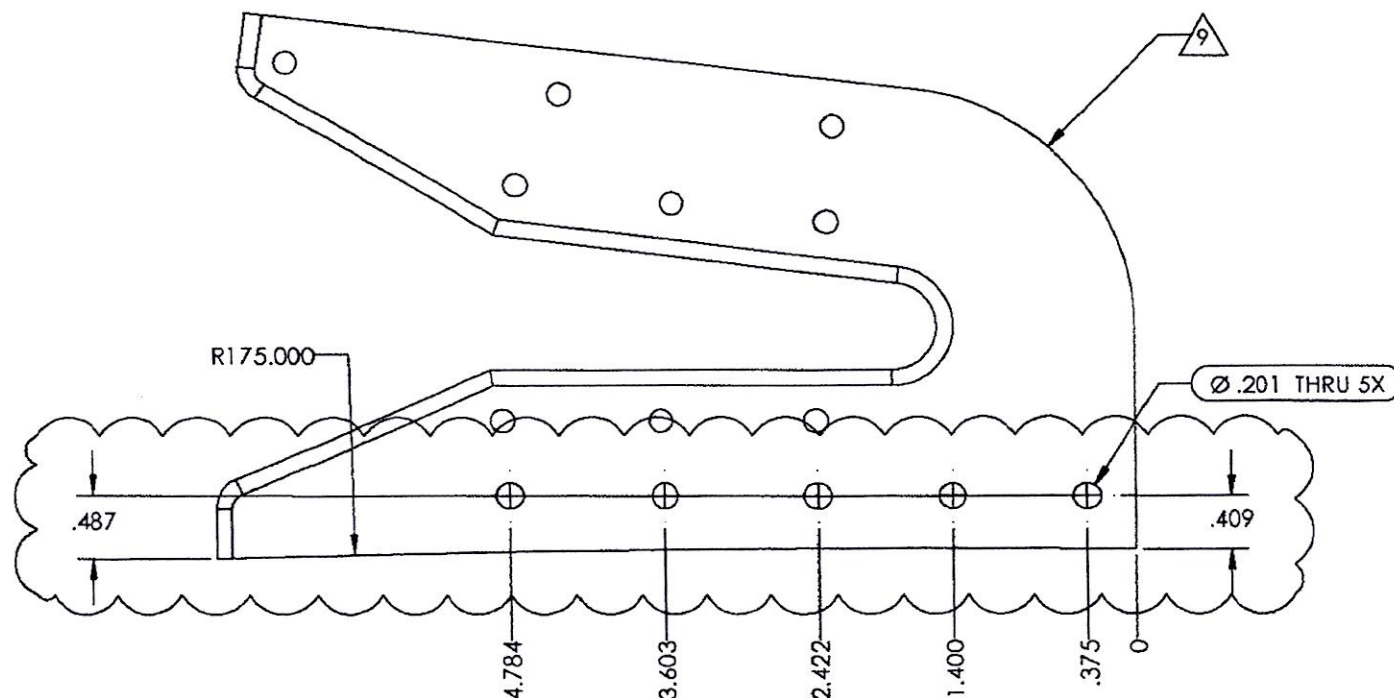
EFF. CURRENT ORDER

REASON: REVISED DIMENSIONS

ECR: N/A

ACTION ITEM:
1.

SHEET 7, ZONE C3 IS:



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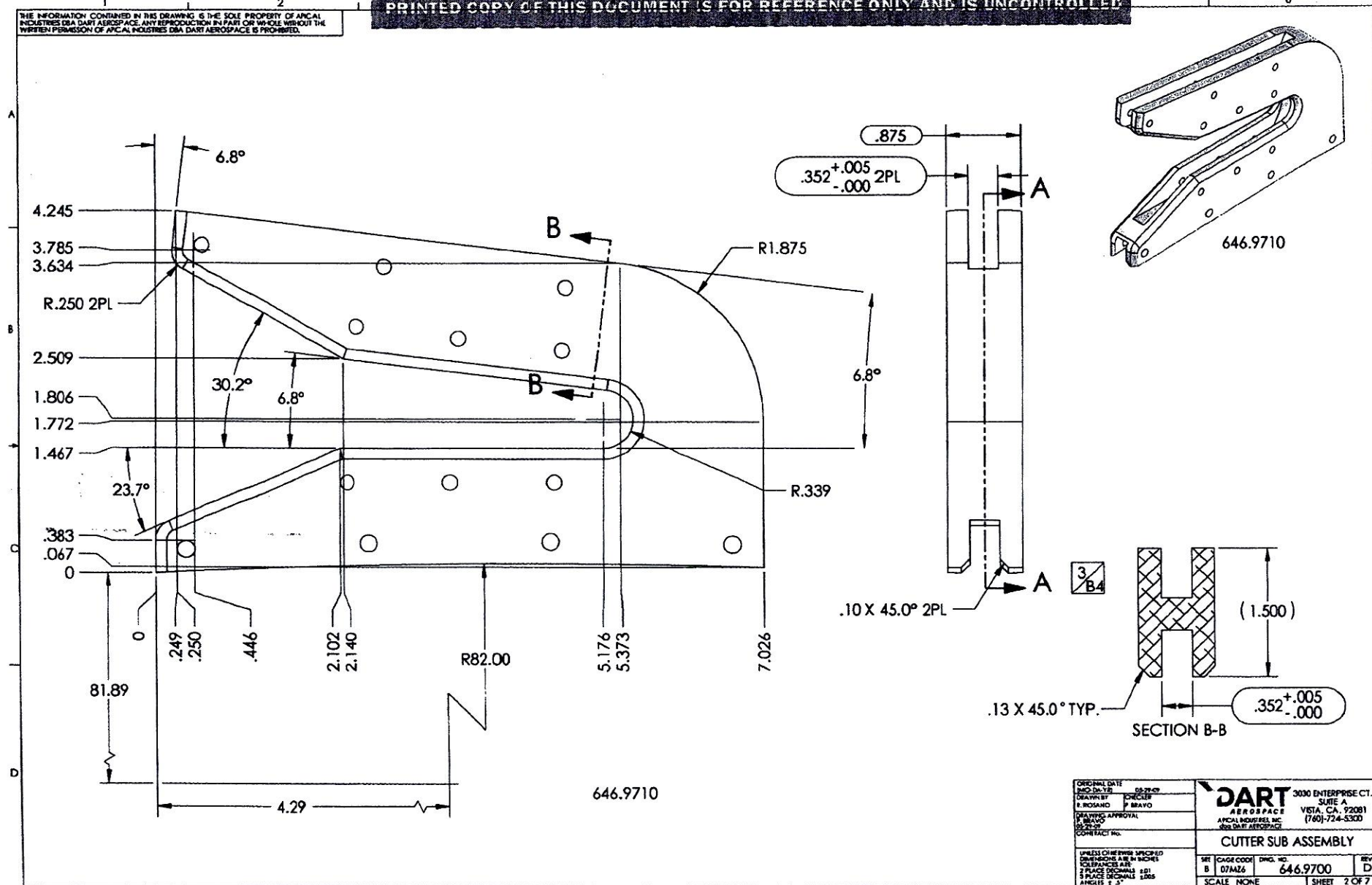
DOCUMENTS EFFECTED: ☐ PATTERN ☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY
☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED
☐ YES ☒ NO

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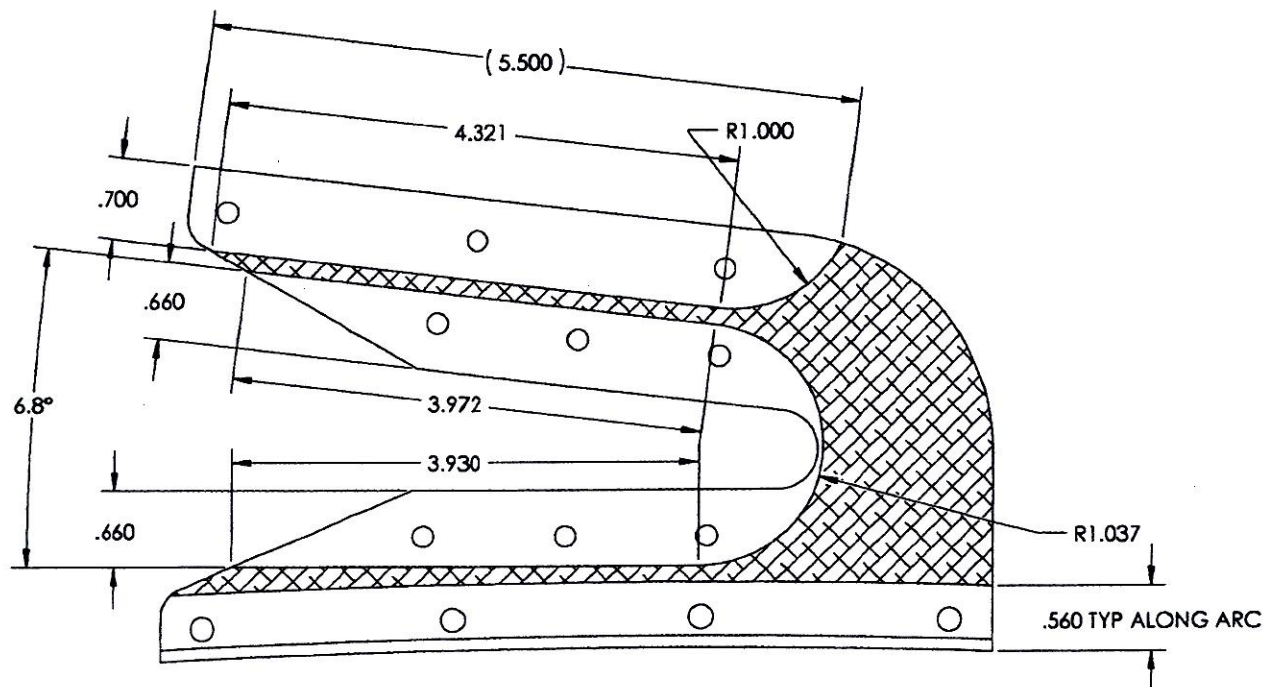
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OVERALL DATE		05-29-07	
DRAWN BY		P. BRAVO	
CHECKED BY		P. BRAVO	
DRAWING APPROVAL		P. BRAVO	
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED			
DIMENSIONS ARE IN INCHES			
TOLERANCES ARE			
2 PLACE DECIMALS ±.01			
3 PLACE DECIMALS ±.005			
ANGLES ±.5°			
DART		3030 ENTERPRISE CT., SUITE A	
AEROSPACE		VISTA, CA, 92081	
APCAL INDUSTRIES, INC.		(760) 724-5300	
CUTTER SUB ASSEMBLY			
REV	CAGE CODE	DWG. NO.	REV.
B	074A26	646.9700	D
SCALE NONE		SHEET 2 OF 7	

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SECTION A-A 2/C6

646.9710

ORIGINAL DATE 06-20-01		3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
DRAWN BY J. KOSKOWSKI	CHECKED J. KOSKOWSKI	DART AEROSPACE APICAL INDUSTRIES INC. DART AEROSPACE	
DESIGNED BY J. KOSKOWSKI		CUTTER SUB ASSEMBLY	
CONTRACT NO.		SCALE NONE	SHEET 3 OF 7
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 ANGLES ±.5°		REV D	646.9700

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